

Date: Wednesday, 01/10/2008 9:50:53 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 42369	
Estimate Number : 12882	
P.O. Number :	Part Number : D3560042
This Issue : 01/10/2008 S.O. No. :	Drawing Number : D3560 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 41287	Material :
Written By :	Due Date : 03/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08. 10. 09</u>	
Comment : Est Rev:A New Issue 07.05.24 EC	
est rev B ECN 987 07.10.09 EC verified by: DD	
Est Rev:C ECN1048 07-12-18 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.4648 f(s)/Unit Total: 14.6475 f(s)
 6061-T6 Bar 0.50" x 5.00"
 Batch: M107244 X 1 part
M106027X M106858 X 2 parts M6061T6 - 6000 x 0500
M109025 X 6 parts 8/08/10

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 16.750" long

8/08/10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

ml (J.L. 08/10/11) (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/10/11 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/10/2008 9:50:53 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 42369

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DTP 08/10/11

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE 342279=6 342417=4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *th*
- 2- set up bracket and arm on jig *th*
- 3- preheat bracket and arm with torch *th*
- 4- clean before welding with brush *th*
- 5- set up machine to 135 amps *th*
- 6- weld across bottom and top ends *th*
- 7- reheat with torch (65 deg C) *th*
- 8- on one side weld from bottom to top half way *th*
- 9- same for other side (half way) *th*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *th*
- 11- same for remaining side (ease off pedal near end) *th*

Welded M108350

M109560

08.12.16

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/12/16

(10)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.12.16 BE

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 42369

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.12.17

10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/12/17 (10)

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

B 41708

08/12/17 (10)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/12/17 (10)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/17 (10)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST152

08/12/18 (10)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/18 (10)

Job Completion



MF 08-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42369
Description: Arm		Part Number: D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø.5068	✓			
Ø0.196	+0.005/-0.001	Ø.197	✓			
Ø1.000	+0.010/-0.001	Ø1.003	✓			
0.500	+/-0.010	.493	✓			
0.250	+/-0.010	.252	✓			
0.275	+/-0.010	.275	✓			
0.188	+/-0.010	.188	✓			
2.000	+/-0.010	2.000	✓			
1.700	+/-0.010	1.750	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø.384 x 100°	✓			
0.250 Deep	+/-0.010	.258	✓			

Measured by: JMK	Audited by: DJP	Prototype Approval:	N/A
Date: 08/10/10	Date: 08/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

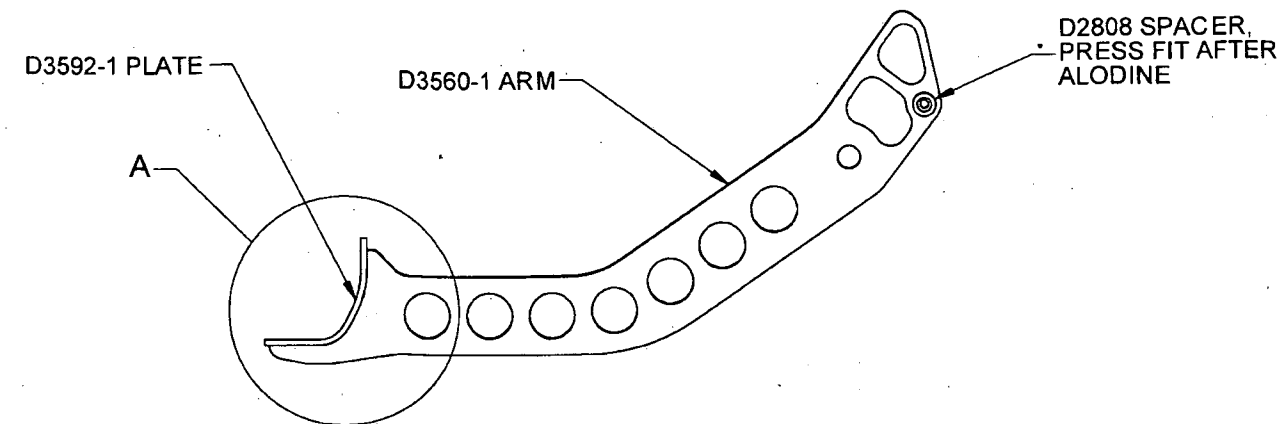
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

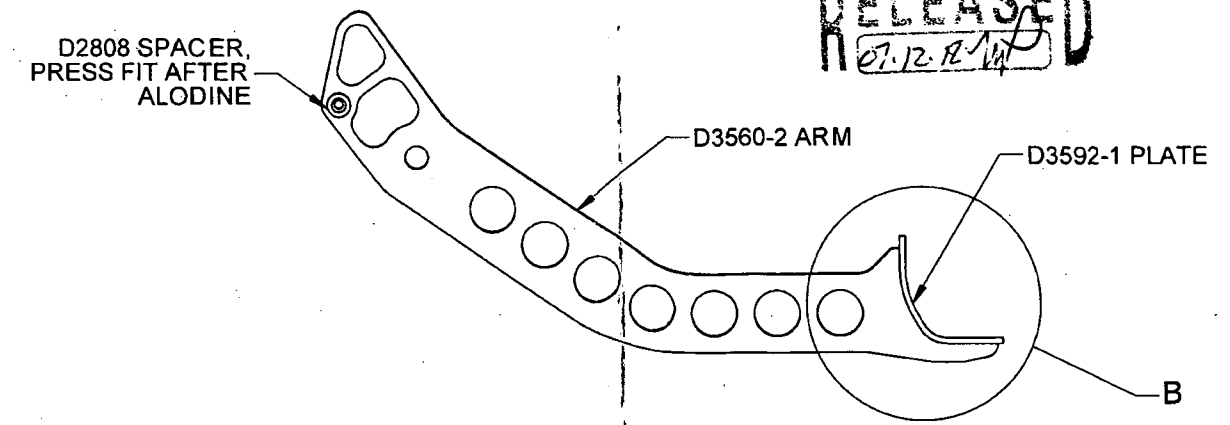
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

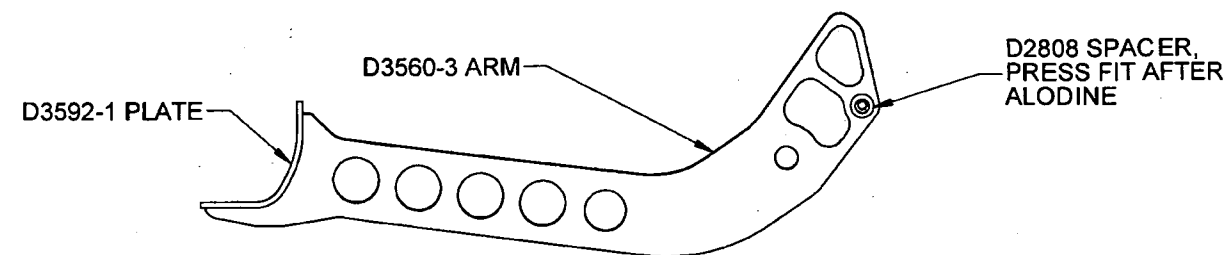
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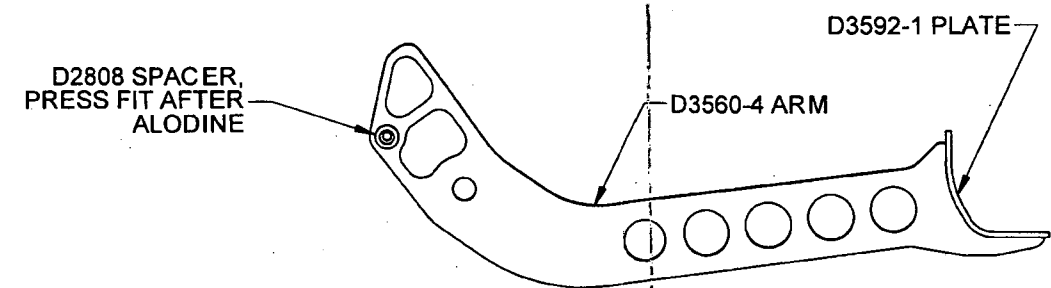
D3560-041 ARM WELDMENT



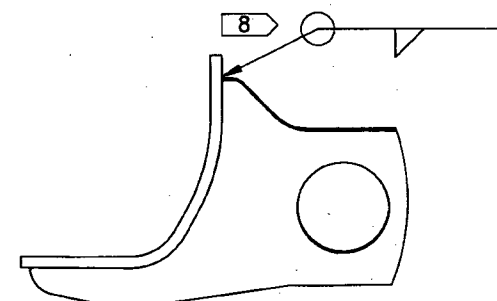
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1 : 2**

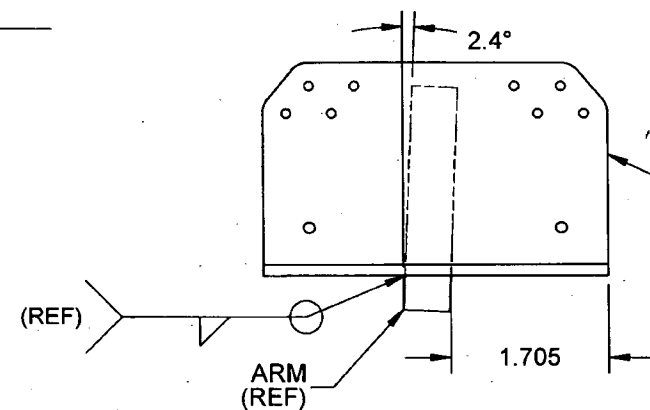
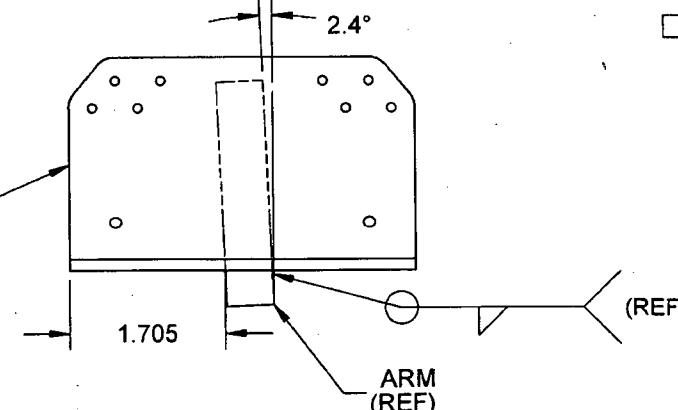
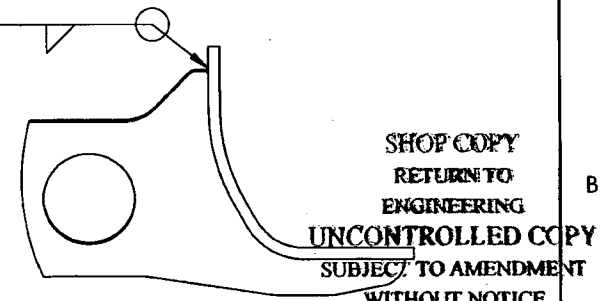


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1 : 2**

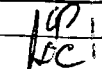


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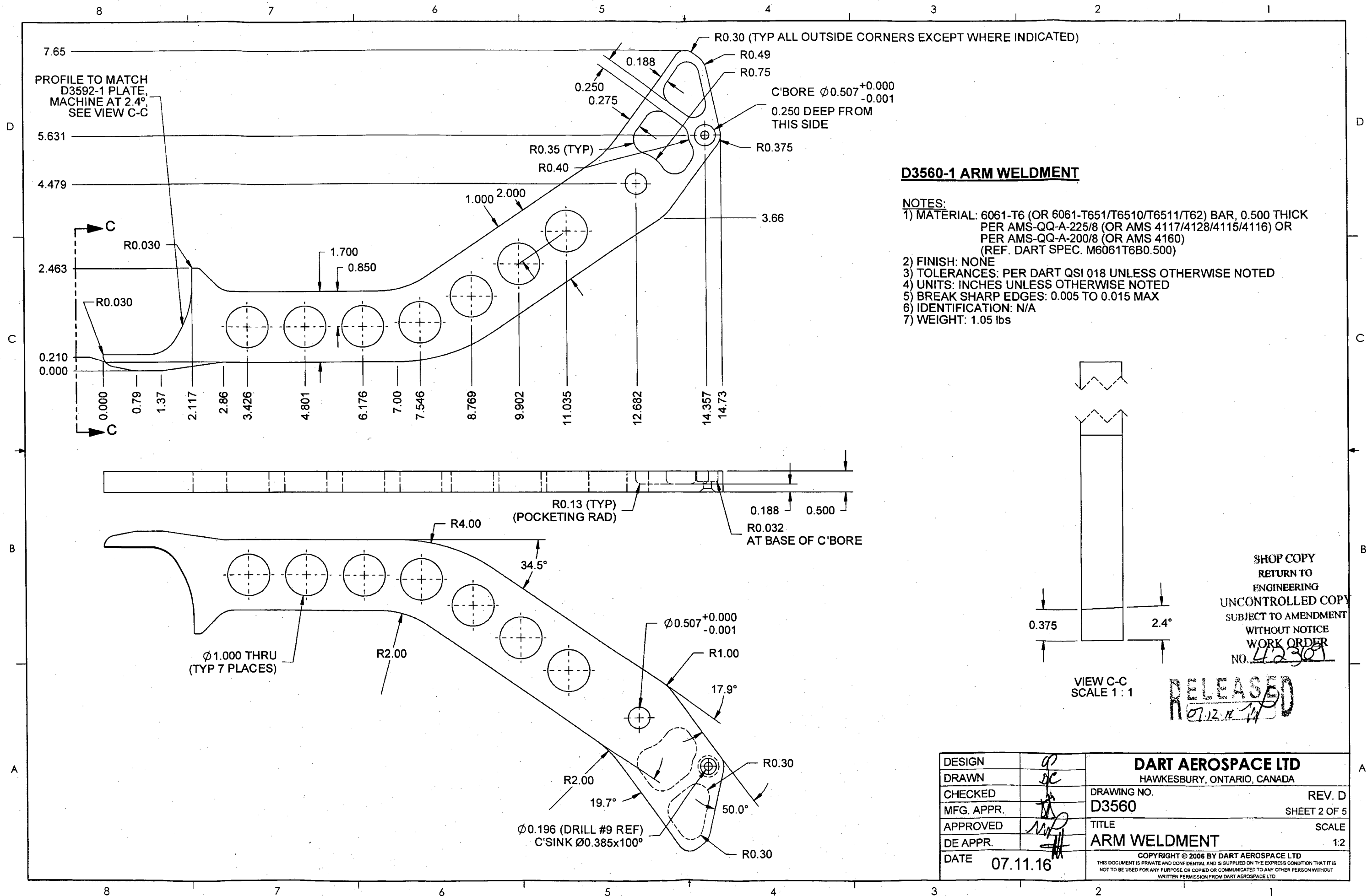
PARTS LIST

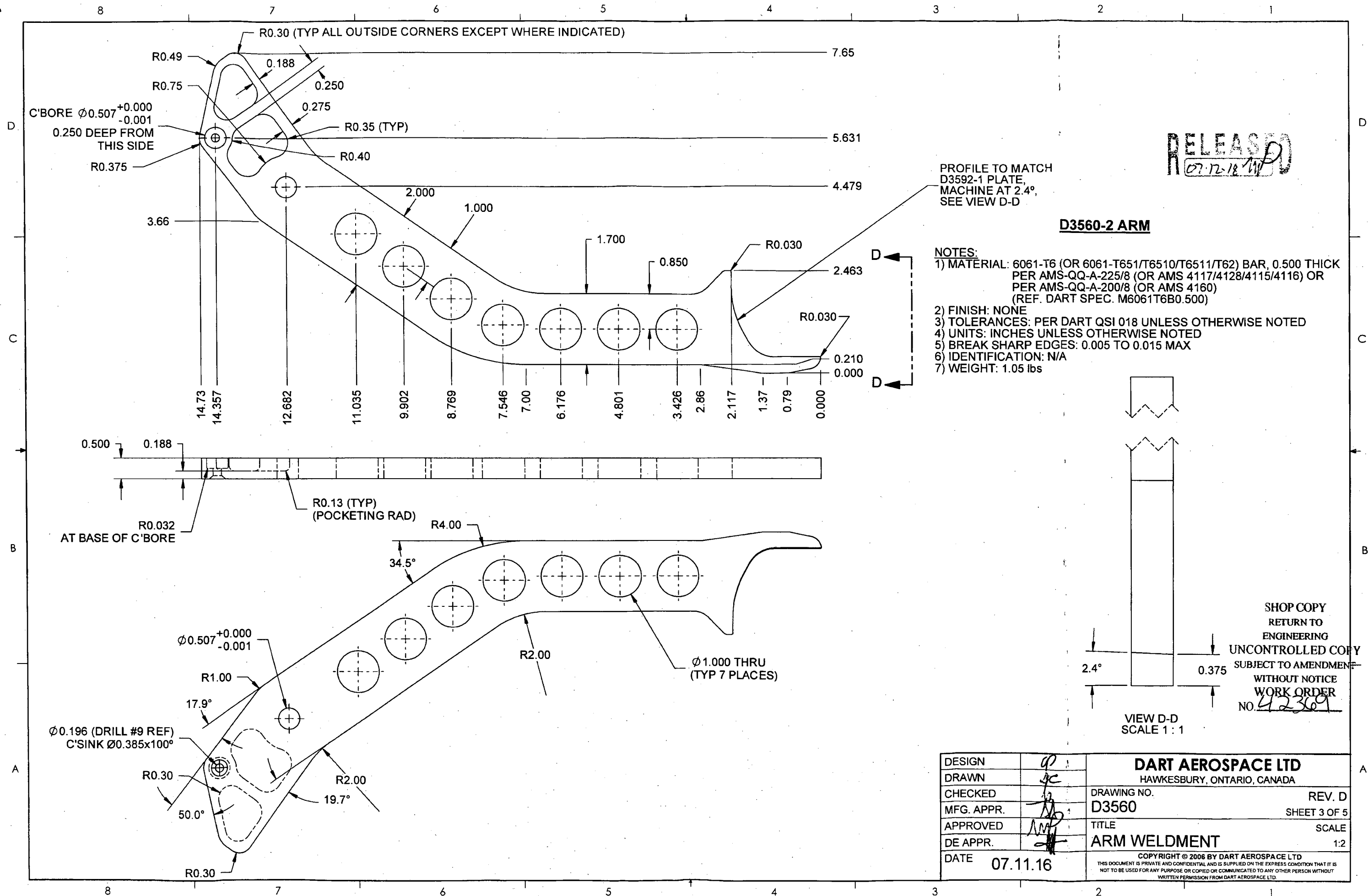
QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

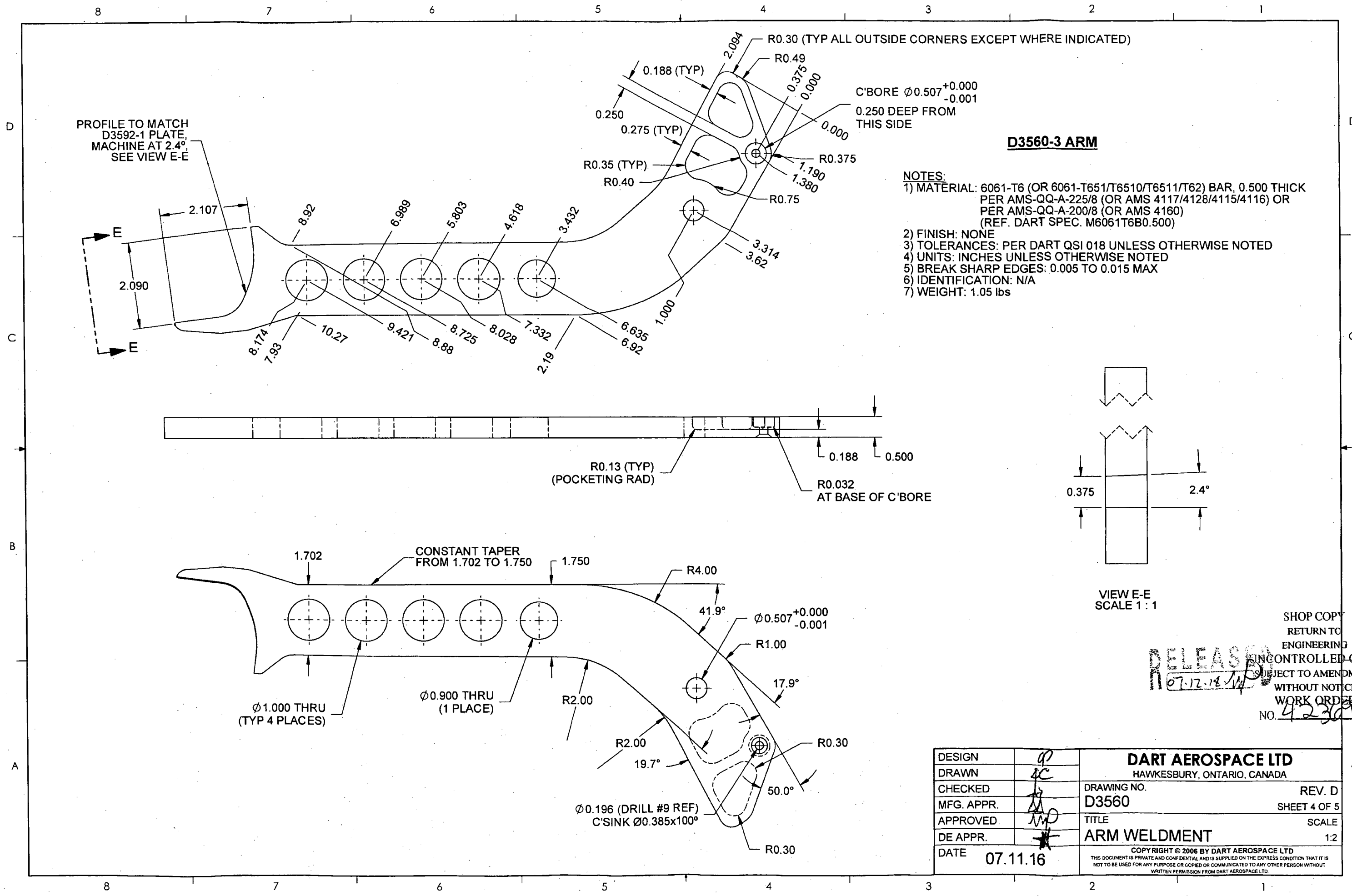
- NOTES:**
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.23 lbs (TYP)
8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION		BY DATE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:4
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